



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-341BL
Job Sheet 166606



5004202

Part No: D206-642-341BL

Job Qty: 1 ea

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/12/17

Job Tracking No:

Due Date: 10/27/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV F(DEO) IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC IPP rev K 10.08.03 chg ms27039-1-08 for "C" type EC verf: DD IPP Rev: L 12.11.22 now swage per ecn12-679 DD verf: JLM IPP Rev: M 14.04.25 Ecn14-520 DD verf: JLM IPP Rev: N 15.10.09 ADDED BL DD VERF: JLM IPP Rev: O 16.01.22 PAR16-484 DD VERF: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea	10/26/17	0.00	0.00	Start up container	
100	DC	1 pcs	10/26/17	0.00	0.00	DC	
110	Skidtubes	1 pcs	10/26/17	0.00	1.58	Skidtubes	
115	QC	1 pcs	10/26/17	0.00	0.00	QC5	
116	QC	1 pcs	10/26/17	0.00	0.00	QC9	
120	HandFinish	1 pcs	10/26/17	0.00	1.17	HandFinish1	
125	QC	1 pcs	10/26/17	0.00	0.00	QC7	
130	Skidtubes	1 pcs	10/26/17	0.00	1.58	Skidtubes	
140	QC	1 pcs	10/26/17	0.00	0.00	QC5	
150	Skidtubes	1 pcs	10/26/17	0.00	1.58	Skidtubes	
180	QC	1 pcs	10/26/17	0.00	0.00	QC5	
190	HandFinish	1 pcs	10/26/17	0.00	1.17	HandFinish2	
200	Purchasing	1 pcs	10/26/17	0.00	0.00	Purchasing	
205	QC	1 pcs	10/26/17	0.00	0.00	QC6	
210	QC	1 pcs	10/26/17	0.00	0.00	QC14	
220	HandFinish	1 pcs	10/27/17	0.00	1.17	HandFinish4	
230	QC	1 pcs	10/27/17	0.00	0.00	QC3	
240	QC	1 pcs	10/27/17	0.00	0.00	QC5	
250	Packaging	1 pcs	10/27/17	0.00	0.00	Packaging3	
260	QC21-FG	1 Ea	10/27/17	0.00	0.00	QC21	

Part Op 100 - Photocopy bluefile and create labels per PPP D206-642-341 CHG005

Descriptions: 110 - 1-Deburr Fwd edge of tube 2-Scribe "Identify Batch Number" 3-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 4-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R Aluminum Rod 136158 / M137133 5-Grind weld flush to cap on top surface only. 6-Cut aft end to length as per dwg D2650 7-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. 8-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 9-Open Aft Cap Hole using #6 Drill Bit 10-Open holes for Tow Ring to Ø 0.625" as per Dwg D2650, D2650-5 Drilling Detail 11-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650 12- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 13-Deburr.

130 - 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: 17/10/23 Time: 15:30 Finish Date: 17/10/23 Time: 15:45 A/R Sikaflex-291 M138535 Sikaflex expiry date: 2018-04-21

150 - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____		Date: _____		Work Order update only ☐	
Work Order _____		DISPOSITION			
Part _____		AGAINST DEPARTMENT/PROCESS			
NCR _____		Cross tube ☐		Water Jet ☐	
Date: _____		all Fab ☐		Prod. Eng. Coord. ☐	
		finishing ☐		Rec/Store/Packaging ☐	
		site ☐		Supplier ☐	
				Engineering ☐	
				Quality ☐	
				Other ☐	
				MRB (QSI042) Approval	
		situation _____		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Job No: 166606
 Mtg Date: 10/31/17

Change No: _____
 Quantity: _____
 Operation: _____
 Revision: _____
 PART NO: _____

D206-642-341BL
 Replacement Skidtube (Fits LH or RH)

DART AEROSPACE
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Root Cause			CATEGORY		
Environment	☐	No Re-verification	☐	Power Loss/Surge	☐
Design	☐	Operator	☐	Folio/Program	☐
Doc/Data	☐	Offset/Setup	☐	Grain	☐
Equip/Tooling	☐	Supplier	☐	Weld	☐
Handling/Pre	☐	Training	☐	Wrong Stock Pulled	☐
Material	☐	Use for Testing	☐	Out of Sequence	☐
Internal Transport	☐	Poor Information	☐	Off-set	☐
Tribal Knowledge	☐	Rushing	☐	Mislabeled	☐
LOA	☐	Product Improvement	☐	Fit/Function	☐
Substation	☐	Process Improvement	☐	Misaligned/off center	☐
Past Expiry Date	☐	Manufacturing Process	☐	Positioned Wrong	☐
Misidentified	☐	Past Due	☐	Outside Dimensions	☐
			OTHER :		

200 - ISSUE PO 39200 ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER
 PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start
 Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish
 Time: _____ CLEAR DELFLEET B _____

DAS
 73
 001 3

2017

220 - 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing
 wearpad/wearplate. A/R Sikaflex-291 M1137526 Sikaflex expiry date: 12/4 2-Install O-Rings D2651-3 on
 plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06
 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R
 Sikaflex-291 M1137526 Sikaflex expiry date: 12/11 6- Install D2680-041 Nut Plate as per Dwg D2650
 7-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: M1137522
 250 - Identify and pack for shipping as per PPP D206-642-341 Location: FG083

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2620 <u>164 474</u>	1	30	0	0
	D2647 <u>8163996</u>	1	41	0	0
	D2654-5 <u>8164376</u>	1	3	0	0
150-Skidtubes	D4720-1 <u>161569</u>	19	590	0	0
220-HandFinish	ALS4-1032-130 <u>M1136 819</u>	54	120	0	0
	CCR264SS3-3	2	298	0	0
	CR3212-4-03	2	249	0	0
	D2646BL <u>F165596</u>	1	14	0	0
	D2651-1BL <u>F161227</u>	14	521	0	0
	D2651-3 <u>F161517</u>	14	544	0	0
	D2680-041 <u>M164 243-119</u>	1	77	0	0
	D3537-1 <u>M16404-104</u>	6	107	0	0
	<u>D3537-3</u> <u>5005226</u>	1	19	0	0
	D4956-11 <u>F165747</u>	1	20	0	0
	D4956-23 <u>F161262</u>	1	15	0	0
	D4956-35 <u>F161536</u>	1	19	0	0
	MS27039-1-08	2	215	0	0
	MS27039-4-06 <u>F11137951-1</u>	1	88	0	0
	MS27039C1-08 <u>5001078</u>	54	171	0	0
	NAS1149C0332R <u>5001036</u>	54	2,674	0	0
	NAS1149D0332J <u>5002036</u>	2	1,532	0	0
	NAS1149D0463J <u>F1137980</u>	1	1,118	0	0

D3683-1
F11137622 →
F11137321 →
F1138209-1 →

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

F

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166606

OCT 12 2017

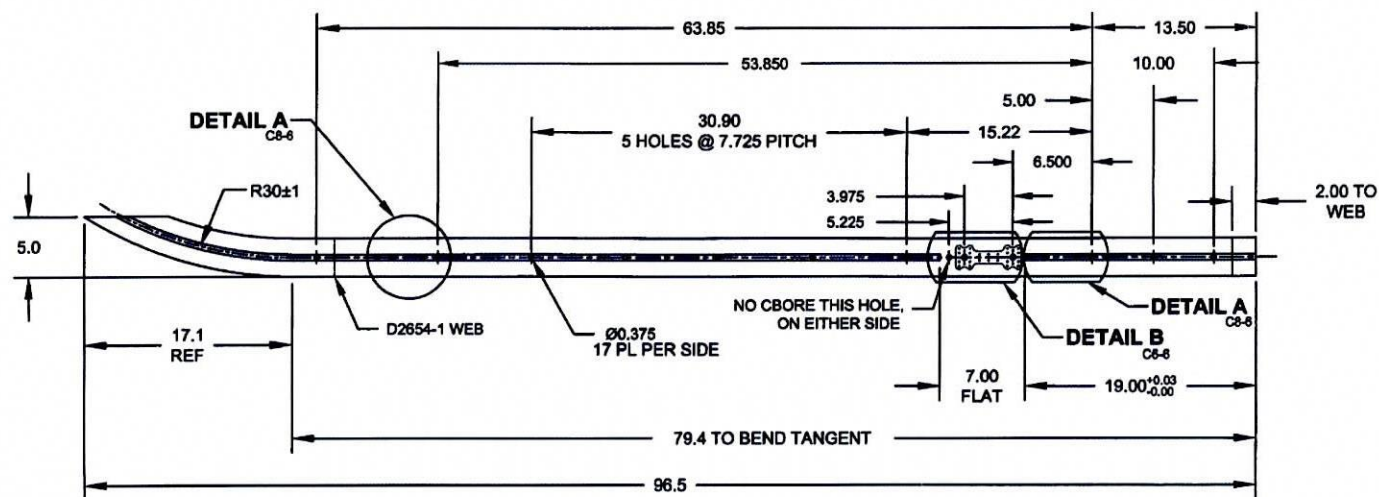
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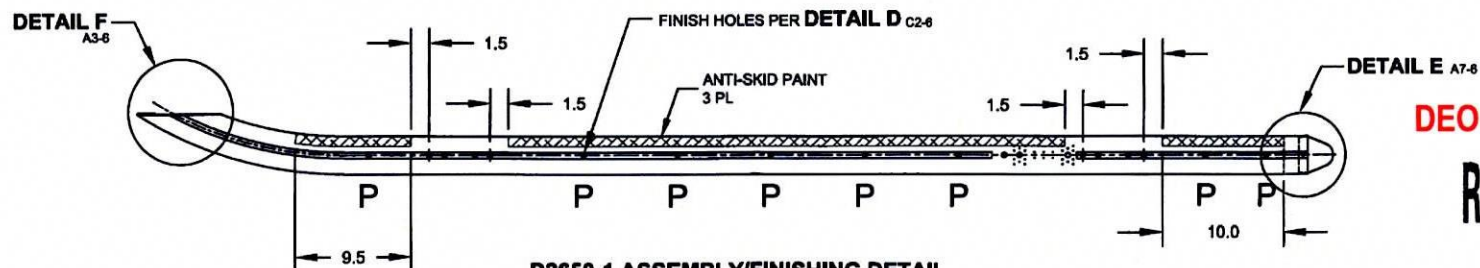
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	08.03.30
D	REDRAW; INCCRP. DE08136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
DATE	08.08.08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



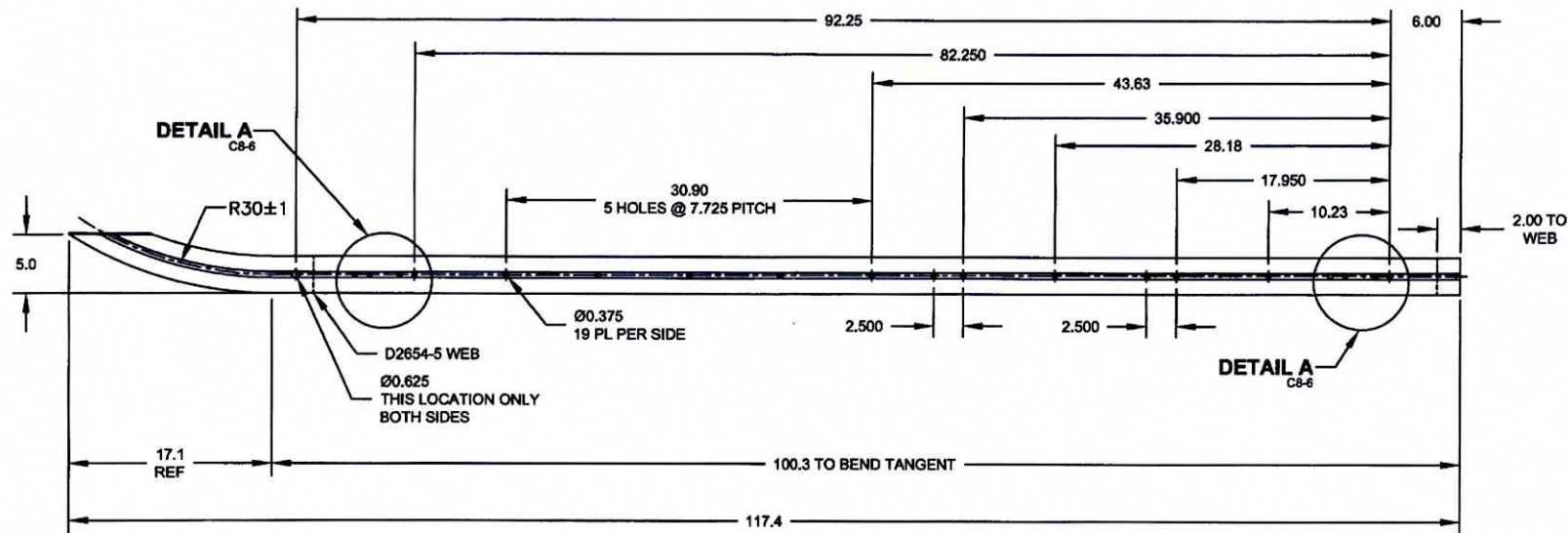
D2650-1 BENDING/DRILLING DETAIL



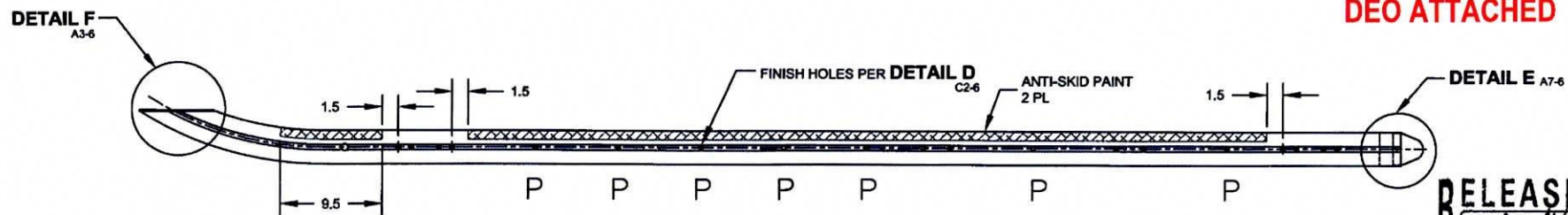
D2650-1 ASSEMBLY/FINISHING DETAIL

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 2 OF 6
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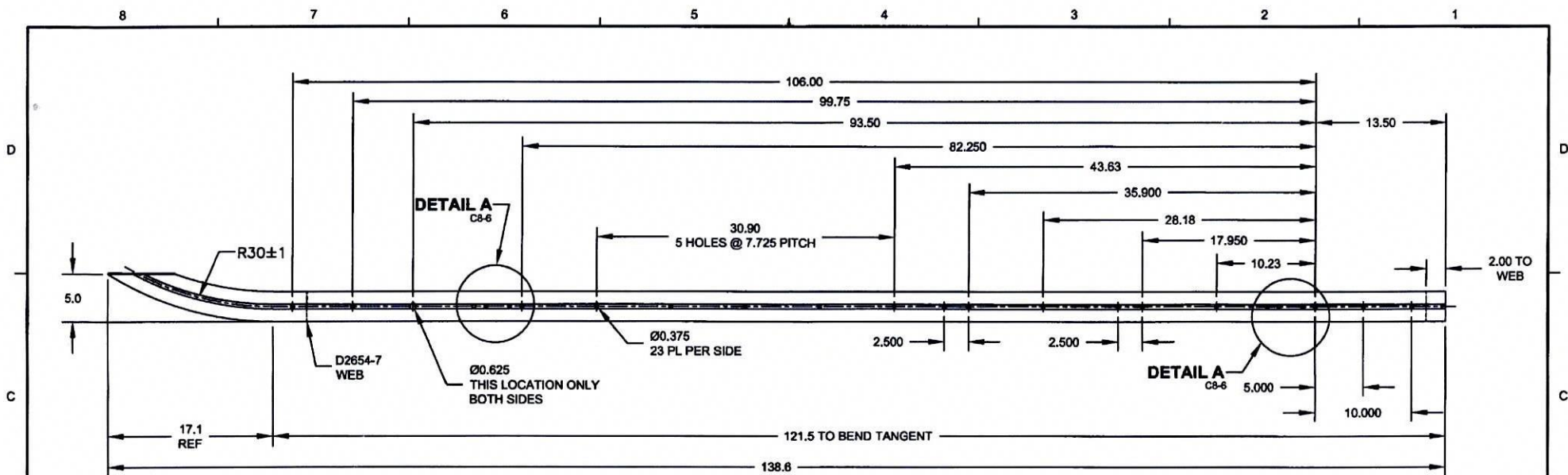
D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	A/S	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 4 OF 6
APPROVED		TITLE	SCALE
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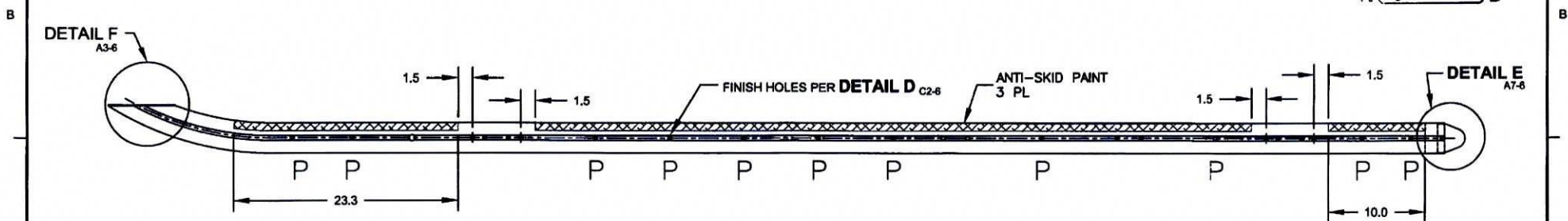
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08.09.22



D2650-7 BENDING/DRILL DETAIL

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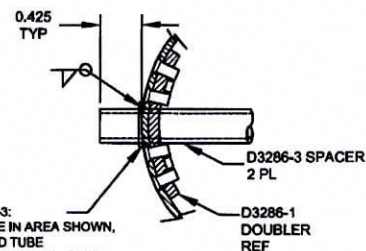
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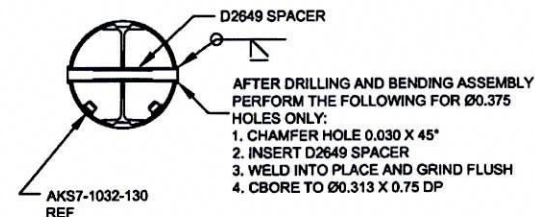
D2650-7 ASSEMBLY/FINISHING DETAIL

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CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 5 OF 6
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SECTION C-C C7-6
SCALE NONE

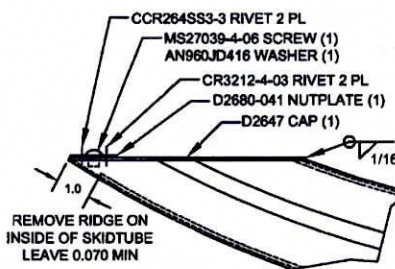


- TO INSTALL D3286-1-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X

B4-2
B4-3
B4-4
B4-5



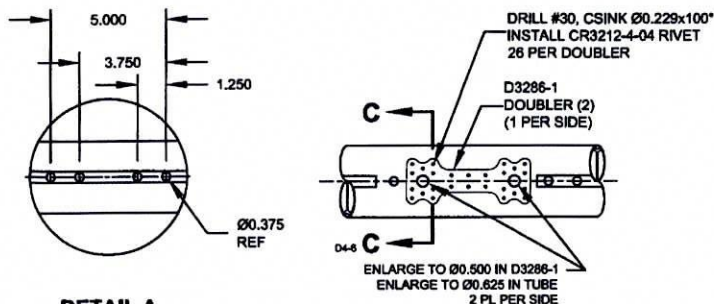
DETAIL F
SCALE NONE

B8-2
B8-3
B8-4
B8-5

- DETAIL F NOTES:**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED

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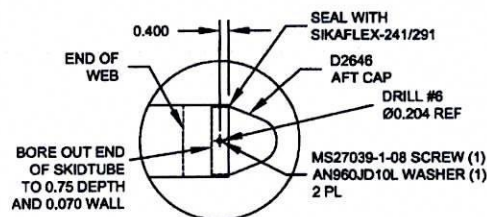


DETAIL A
SCALE 2X

C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D8-6

DETAIL B
SCALE 2X

C3-2
C3-3



DETAIL E
SCALE 2X

B2-2
B2-3
B1-4
B1-5

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>A.P.</i>	MFG. APPR. <i>AA</i>	APPROVED <i>TH</i>		DE APPR. <i>TH</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

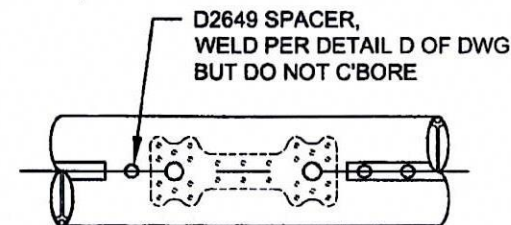
QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
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ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.

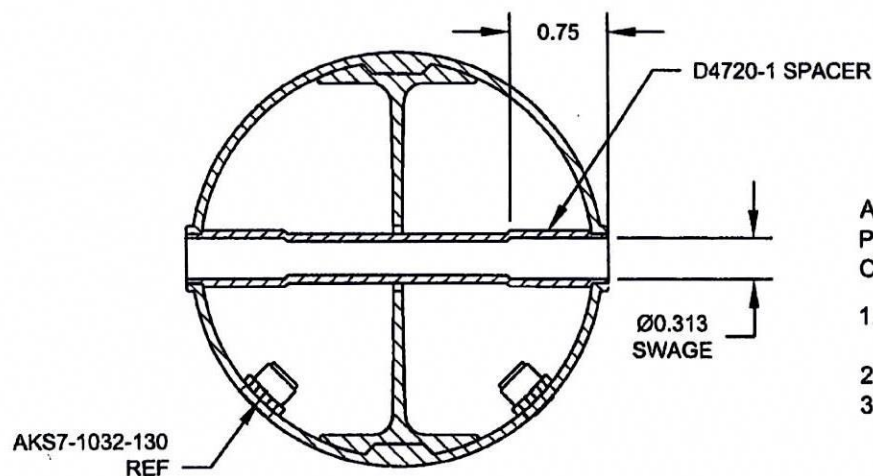
C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
MP



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

